

Date: 7/16/2007 2:42:21 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER					
Job Number	: 33543								
Estimate Number	: 10764								
P.O. Number	: N/A		Part Number	: D2876					
This Issue	: 7/16/2007		S.O. No.	: N/A		Drawing Number	: D2876 REV B		
Prsht Rev.	: NC					Project Number	: N/A		
First Issue	: N/A		Type	: SMALL /MED FAB		Drawing Revision	: B		
Previous Run	: 31227					Material	: NOTE:1 BLANK MAKES 4 PARTS		
Written By	:					Due Date	: 7/30/2007		
Checked & Approved By	:		: 7/07.07.17			Qty:	120		Um:
Comment	: Esr Rev:B 00.05.19		Added inspect level 8		EC				
	Est Rev:C		Now M6061-T6		06-06-23	JLM			

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S100 6061-T6 .100 Sheet

A standard linear barcode is positioned horizontally across the page, centered below the page number.

Qty.: 0.0542 sf(s)/Unit Total : 6.5016 sf(s)
Material: 6061-T6 (QQ-A-250/8) 0.100" Thick
Batch: M102261 | 18-127-3 8

Comment: FLOW WATER JET

INSPECT PARTS AS THEY COME OFF MACHINE

LB 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

0 SMALL FAB 1

11. *What is the primary purpose of the following statement?*

Comments: SMALL & MEDIUM EAR RESOURCE 1

Remove tabs and Tumble

60 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per OSI 005.4.1

Date: Monday, 7/16/2007 2:42:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 33543

Part Number: D2876

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC7/8/01

(120)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5705*

PC7/8/01

(120)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(120)

Comment: FINAL INSPECTION/W/O RELEASE

1257108101

Job Completion



Jeff 07-08-01

DART AEROSPACE LTD	Work Order:	33543
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by:	Prototype Approval:	N/A
Date: 07-07-30	Date:	Date:	N/A

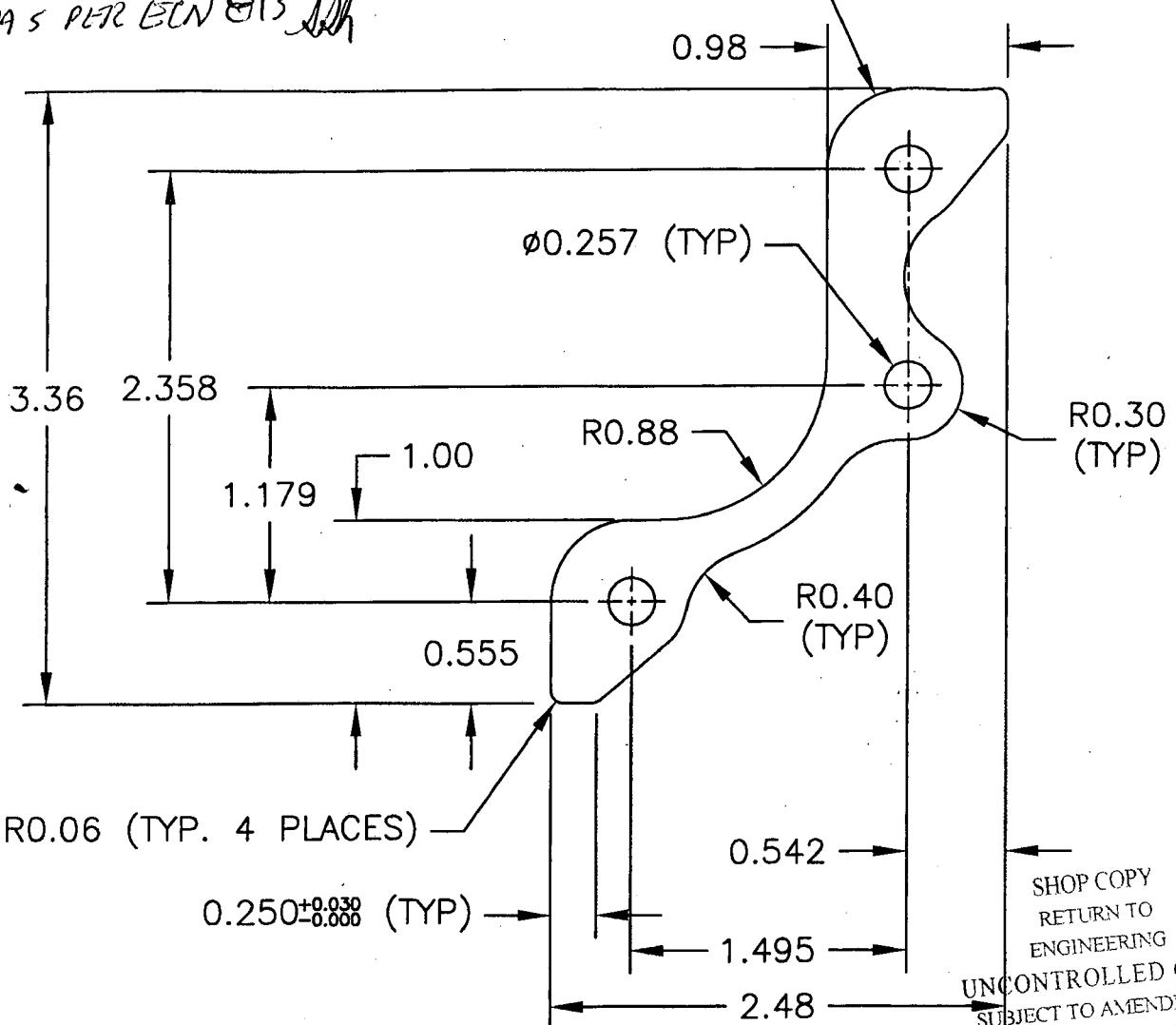
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.15	Removed 0.250 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2876
DATE 06.06.02		TITLE SADDLE SPACER
		REV. B SHEET 1 OF 1 SCALE 1:1
A	99.02.23	NEW ISSUE
B	06.06.02	MATERIAL CHANGE

RELEASED
06.06.22AS PER ECN 813 *MM*

R0.44 (TYP 2 PLACES)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33543*

Copyright © 1999 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.